

Date: Tuesday, 11/14/2006 10:13:29 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : ARM
 Job Number : 29450
 Estimate Number : 12590
 P.O. Number : N/A Part Number : D35604
 This Issue : 11/14/2006 S.O. No. : N/A Drawing Number : D3560 REV A
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : SMALL / MED FAB Drawing Revision : A
 Previous Run : N/A Material : N/A
 Due Date : 11/25/2006 Qty: 5 Um: Each
 Written By :
 Checked & Approved By :
 Comment : Est Rev:A New Issue 06-11-10 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B0500X06000 6061-T6 Bar .50" x 6.0"



Comment: Qty.: 1.0080 f(s)/Unit Total: 5.0400 f(s) 7.8560

6061-T6 Bar .50" x 6.0"

Batch: M101909

M 06 11 20

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3560

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

Note: .507" Dia & .196" Dia Holes are to opened on manual mill after Waterjet

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 MILLING CONV. CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

1-Open .196" Dia hole

2-C'Bore as per Dwg D3560.

3-Ream .507" as per Dwg D3560

Ensure to C'Bore on Corect side

Er 07/01/02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: PD Date: 07/01/02
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: ARM

Job Number: 29450

Part Number: D35604

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

En 07/02/02

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.F. 07/02/02

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WA23

J.F. 07.01.02

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

③
PD 07/01/02

Job Completion



C207101103

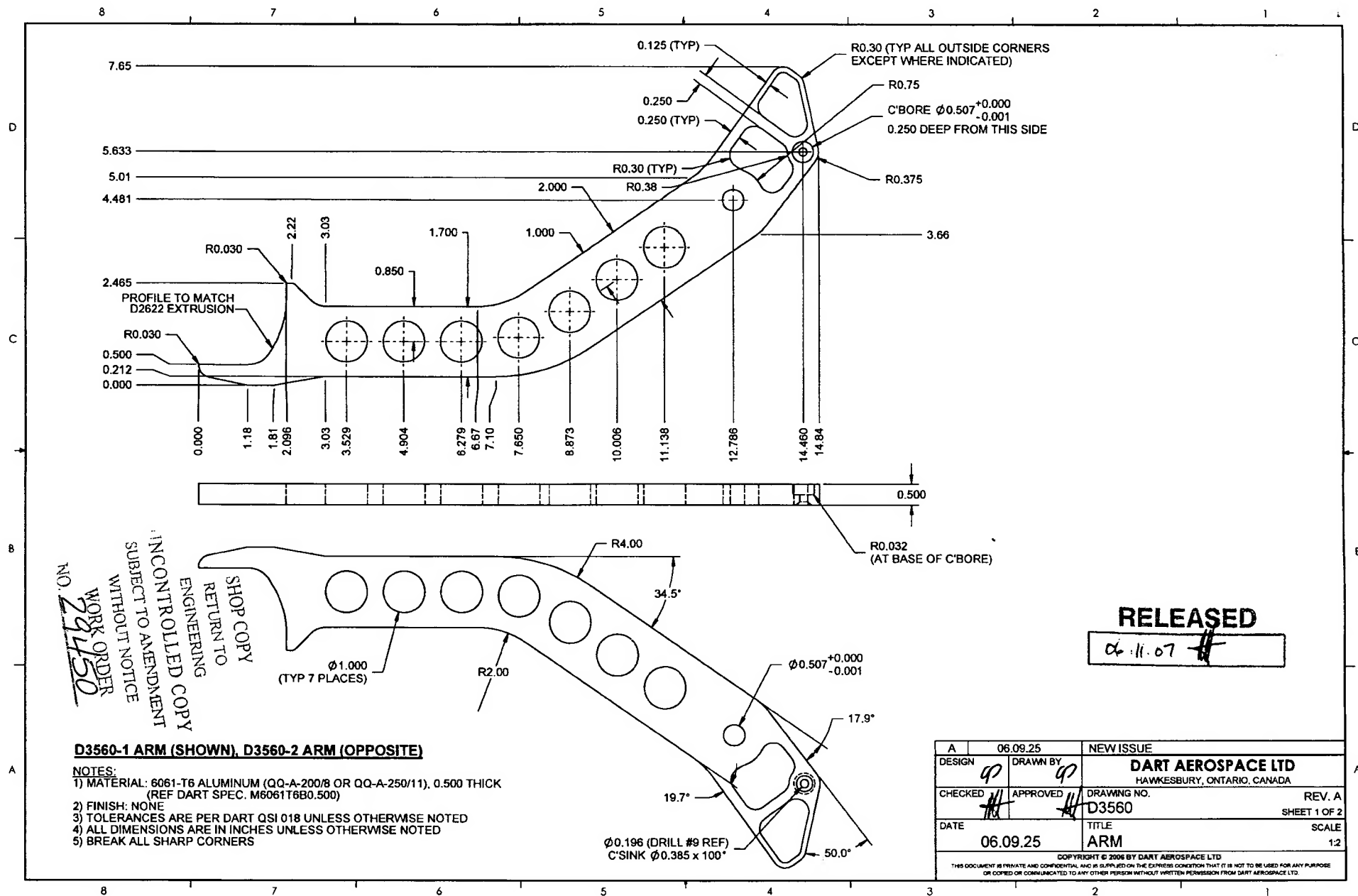
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

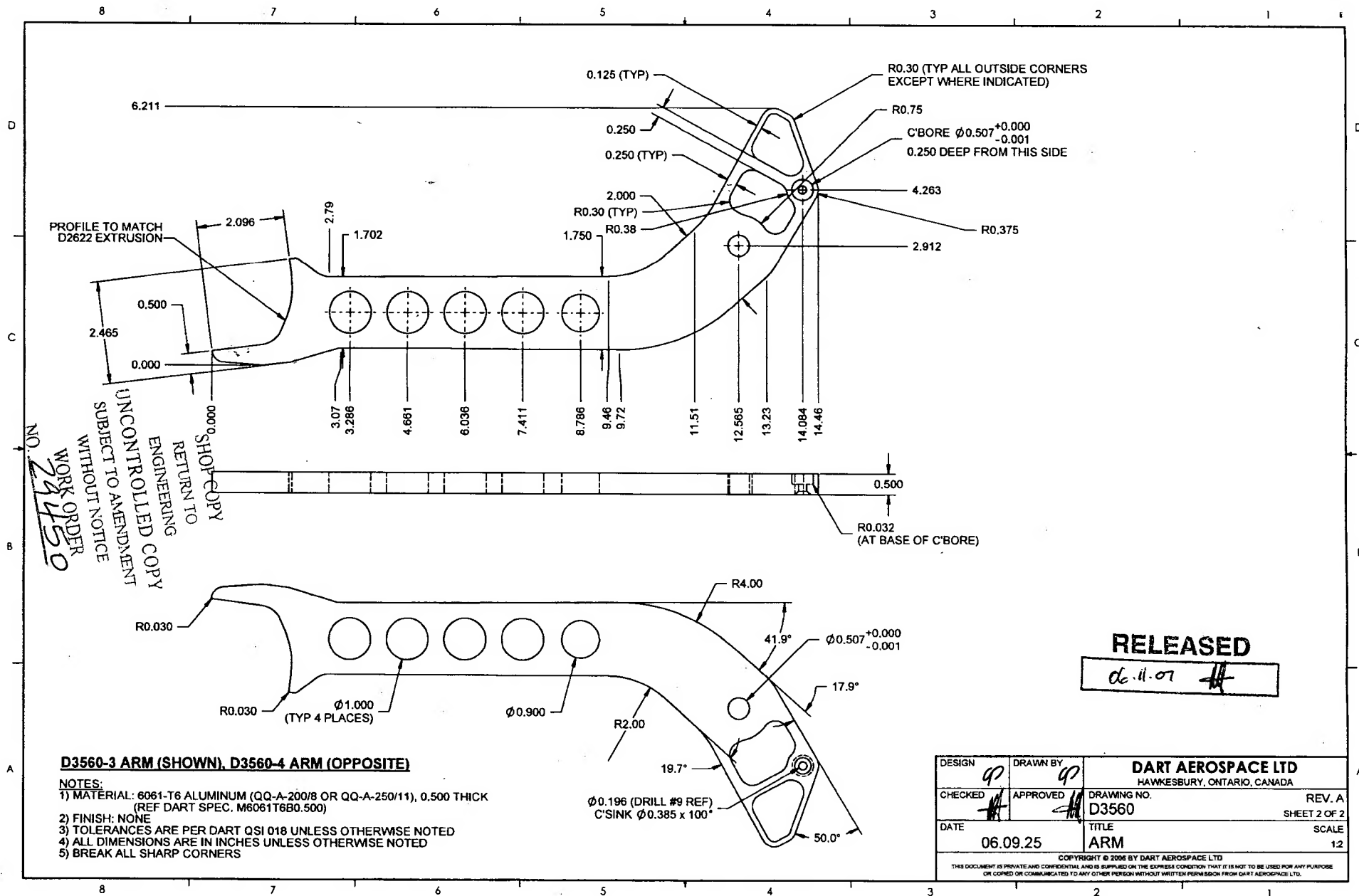
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries





DART AEROSPACE LTD		Work Order: 29450
Description: ARM		Part Number: D3560-4
Inspection Dwg: D3560 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article

☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
φ0.507	+0.000-0.001	0.506			vern	
φ0.196	+0.005-0.001	0.196	✓		vern	
φ0.900	+0.010-0.001	0.900	✓		vern	
φ1.000	+0.010-0.001	1.000	✓		vern	
1.750	+/-0.010	1.751	✓		vern	
1.702	+/-0.010	1.705	✓		vern	
2.465	+/-0.010	2.464	✓		vern	
2.000	+/-0.010	2.003	✓		vern	
0.250	+/-0.010	0.253	✓		vern	
0.250	+/-0.010	0.253	✓		vern	
0.125	+/-0.010	0.128	✓		vern	
0.500	+/-0.010	0.500	✓		vern	
0.507	+0.000 -0.001	0.507	✓		vern	
0.385 x 100°	±0.010 / ±1/2°	0.386 x 100°	✓		vern	
0.507	+0.000 -0.001	0.507	✓		"	
0.250	±0.010	0.248	✓		"	
0.196	+0.005 -0.001	0.200	✓		vern	

Measured by: ml: ml	Inspected by: [Signature]	Prototype Approval: N/A
Date: 06/11/20	Date:	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	